

Split

Work Order ID 147351-2

147351

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Wednesday, June 08, 2016 2:59:22 PM

Item ID: D3065-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Leg Assembly 15
 Start Date: 6/24/2016 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 7/4/2016 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: MJS Date: JUN 10 2016 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3065	Rev B

100

100

Small Fab

Small Fab

Small Fab

Memo

Assemble as per Dwg D3065 and Identify as D3065-041

0.00

0.15

DAS
30
9-89

15x

16/06/22

DAS
36
9-89

110

110

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.03

DAS
30
9-89

15

JUN 22 2016

120

120

Packaging

Packaging

Identify as per dwg & Stock Location: WA002 0.00

Memo

LOCATION : WA002

0.02

DAS
30
9-89

15

JUN 22 2016

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Item ID: D3065-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Leg Assembly
Start Date: 6/24/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 7/4/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.17							
Quality Control									

_____ **MCS** _____ **JUN 23 2016**

MCS **JUN 23 2016**

Picklist Print

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Work Order ID: 147351

147351

Parent Item: D3065-041

D3065-041

Parent Item Name: Step Leg Assembly

Start Date: 6/24/2016

Required Date: 7/4/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPPKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3065-1 *D3065-1* Step Spacer		Manufactured	No			100	Each	0.0000	1	10 20		16/06/21	DAS 36 9-89
						B145086		20x	**				
D3065-3 *D3065-3* Step Spacer		Manufactured	No			100	Each	44.0000	1	10 20		16/06/21	DAS 36 9-89
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				44					
					144986			44					
D3065-5 *D3065-5* Step Leg		Manufactured	No			100	Each	43.0000	2	20 20 40		16/06/21	DAS 36 9-89
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				43					
					144987			43					
D3065-7 *D3065-7* Step Spacer		Manufactured	No			100	Each	0.0000	1	40 10 20		16/06/21	DAS 36 9-89
									**				
						B145086		20x	**				
						B145087							

Picklist Print

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Work Order ID: 147351

147351

Parent Item: D3065-041

D3065-041

Parent Item Name: Step Leg Assembly

Start Date: 6/24/2016

Required Date: 7/4/2016

Start Qty: 10.00

Required Qty: 10.00

MS20470AD4-4

Purchased

No

100

Each

4,136.000

30

300

MS20470AD4-4

Rivet, Universal Head

16/06/22

DAS
36
9-89

Location

Loc Qty

Loc Code

CCK005

2069

M134848

2069

GA

1599

M133922

54

M134294

101

M134574

1444

ST310

468

M132803

468

600

Wednesday, June 08, 2016 2:59:26 PM

Shop Packet Print

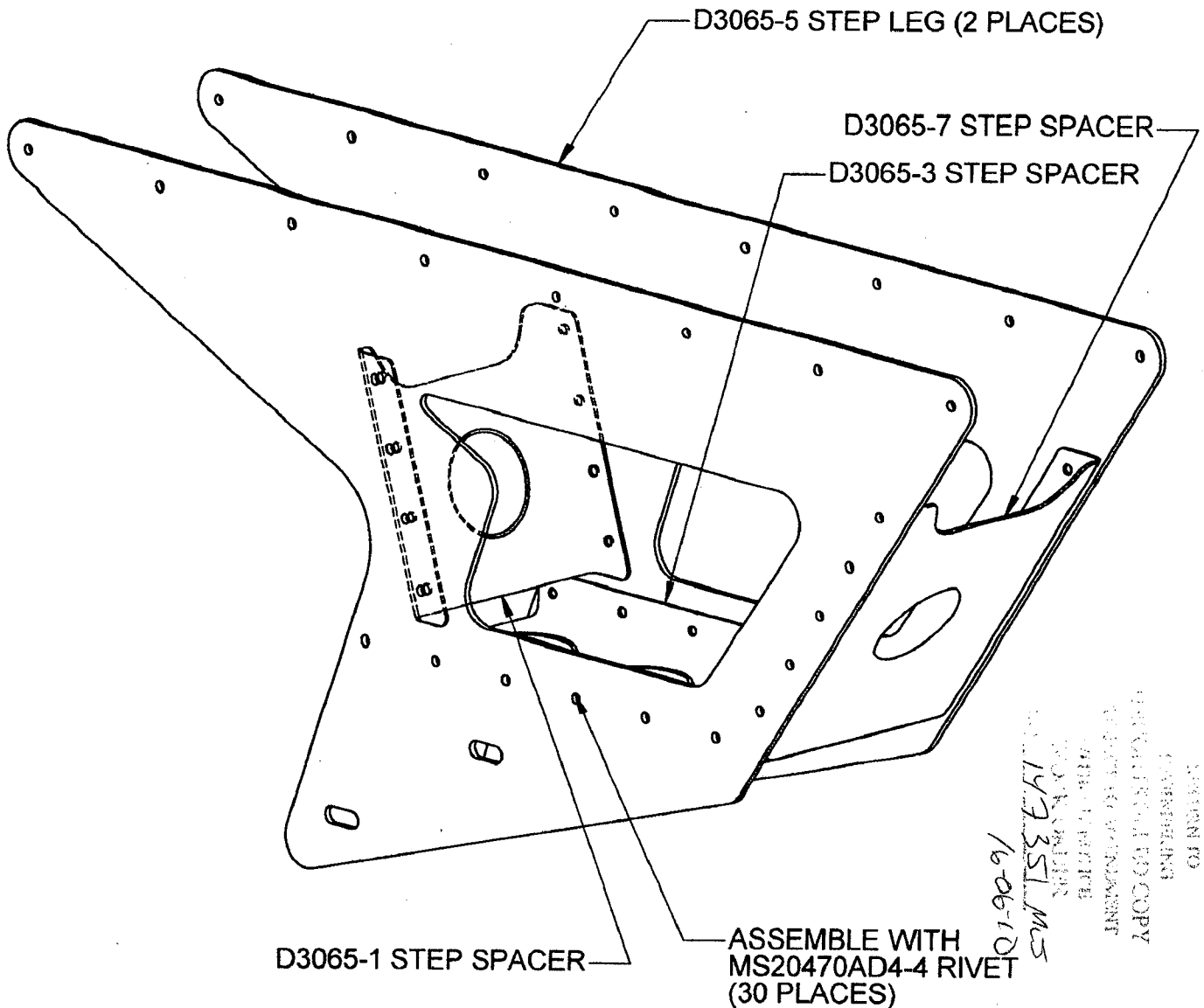
Page 2



DESIGN <i>UP</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06-06-20 *[Signature]*



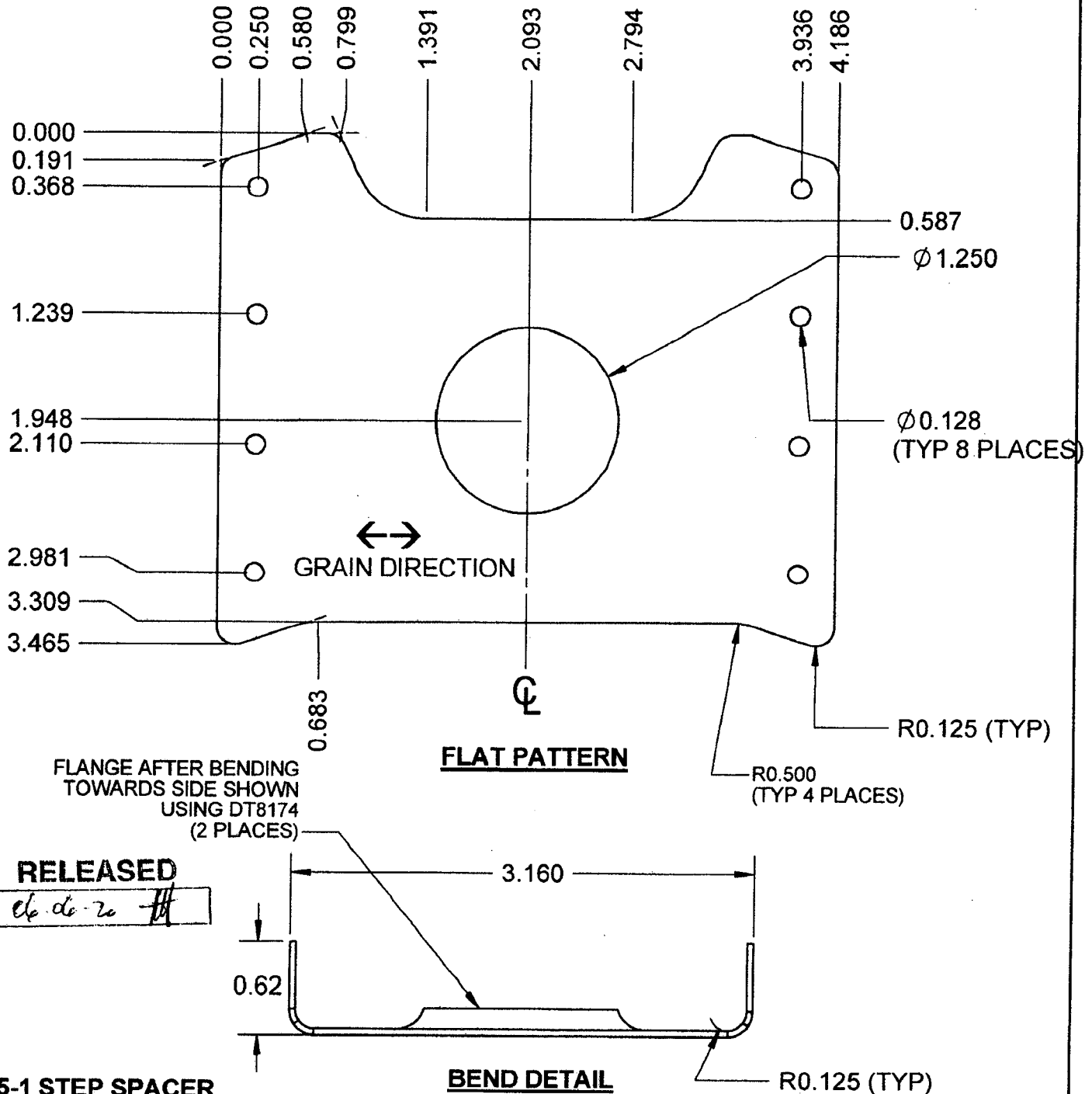
D3065-041 STEP LEG ASSEMBLY

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DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SHEET 2 OF 5 SCALE 1:1

**D3065-1 STEP SPACER****BEND DETAIL**

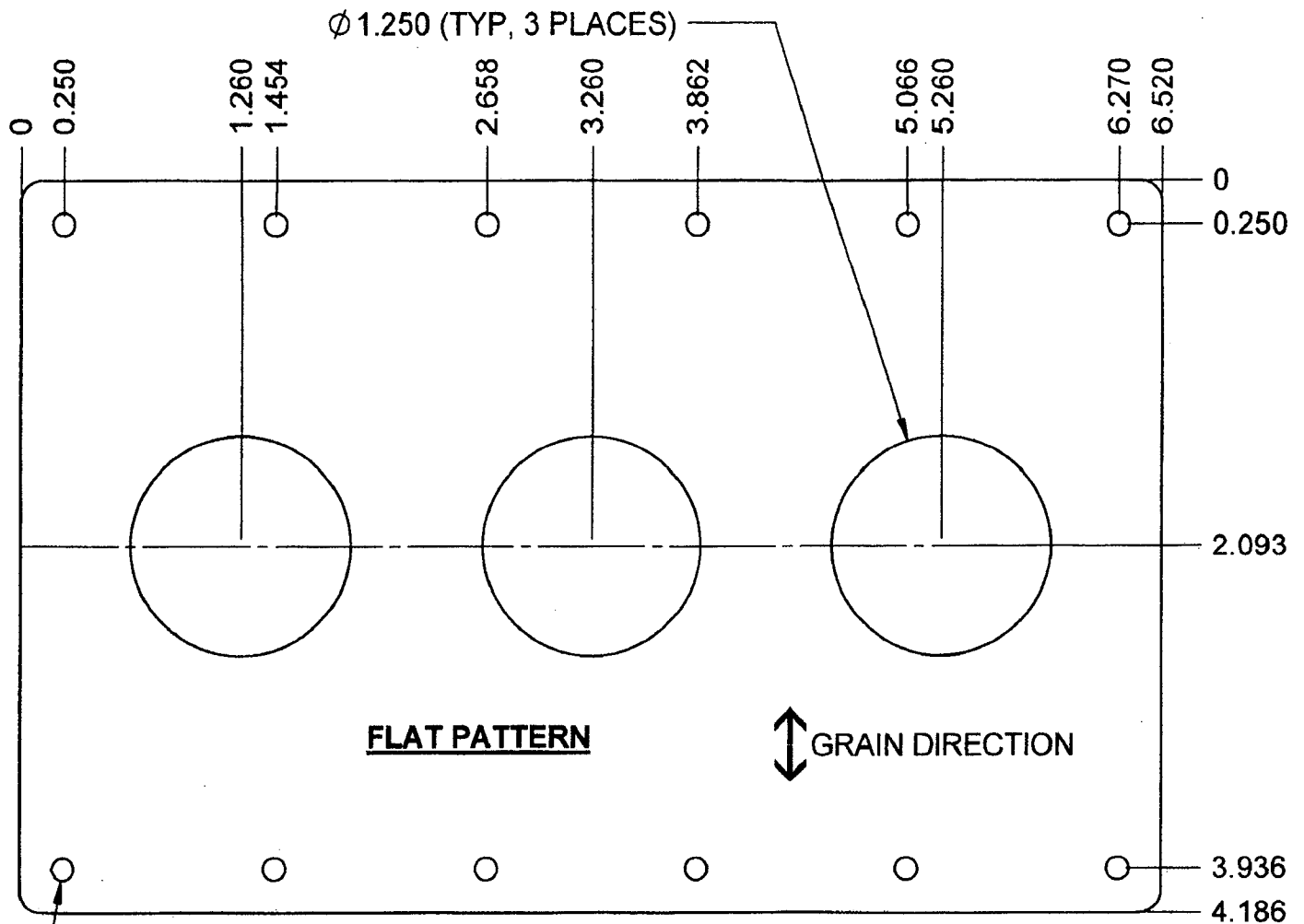
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

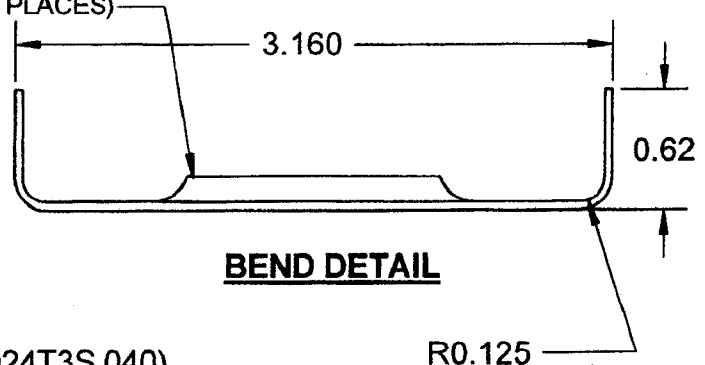


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

66 ct 20 *[Signature]*



D3065-3 STEP SPACER

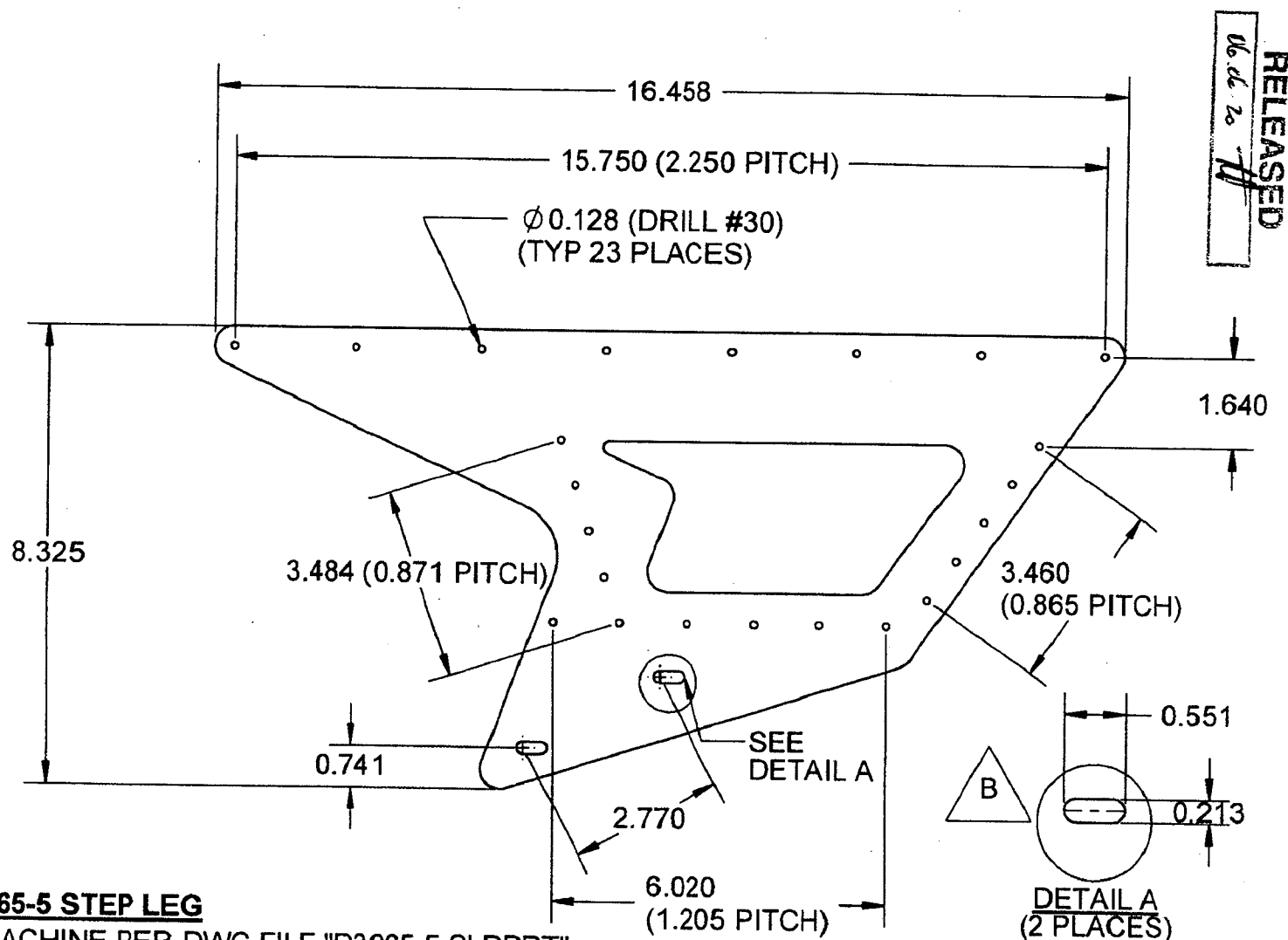
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
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DESIGN	40	DRAWN BY	C.B.	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	06.05.23	DRAWING NO.	D3065	REV. B
		TITLE	STEP LEG ASSEMBLY	SHEET 4 OF 5
				SCALE 1:3



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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